

Work Order ID 152114

Wednesday, October 19, 2016 3:29:08 PM

152114

Page 1

Item ID: PB67-43001-313

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Plate

Start Date: 10/14/2016 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/19/2016 Req'd Qty: 1.00

1

Customer:

Reference:

**DAS
21**

Approvals: Process Plan: **9-89**

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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B67-43001-313	Rev D
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100

FLOW WATER JET

0.00

100

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg B67-43001 Dwg Rev: P Prog Rev: D

****grain direction along 24.50" *****2-Debur if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

Quality Control

PR 10/10/21

2

2

PR 10/10/21

2

DAS

38

9-89

OCT 24 2016

DQA: shf Date: JAN 31QA Closed: shf Date:

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only ☐

Work Order: <u>152114</u> Part No. <u>8367-43001-313</u> NCR No. <u>16-6152</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☒</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☒	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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Date: <u>16-11-08</u>		Step #: <u>130</u>		QTY Effective: <u>1</u>		MRS (QSI042) Approval DAS 9 9-89 <u>16-11-16</u>																																																																	
Description Work Order Deviation Part crack when forming Took bigger die ↳ different die.				Disposition Scrap & destroy make the replace make water jet cut M <u>135147</u> <u>0.5</u>				Completed By DAS 30 9-89 <u>NOV 08 2016</u>																																																															
				Lead hand / Supervisor Approval Verification DAS 9 9-89 <u>NOV 08 2016</u>																																																																			
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Item ID: PB67-43001-313 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Plate
Start Date: 10/14/2016 Start Qty: 1.00 ***1*** Cust Item ID:
Required Date: 10/19/2016 Req'd Qty: 1.00 ***1*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC21- Final Inspection - Work Order Release	0.00							
160							DAS 21 9-89		
QC	Memo	0.00							
Quality Control									
									NOV 14 2016
							DAS 21 9-89		NOV 14 2016

Picklist Print

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Work Order ID: 152114

152114

Parent Item: PB67-43001-313

PR67-43001-313

Parent Item Name: Plate

Start Date: 10/14/2016

Required Date: 10/19/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-06-23 new issue DD verified by:ec
10.10.04 per revC dwg EC verified by:DD

IPP Rev B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.090		Purchased		No		100	sf	42.5000	0.4253	0.447684			

M6061T6S 090

6061-T6 .090 Sheet

PR 16/10/21

Location

Loc Qty

Loc Code

MAT020

42.5

M133699

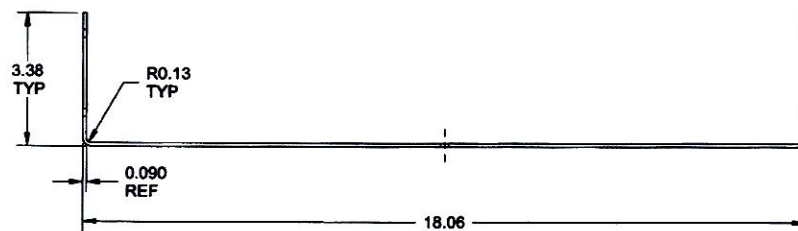
2.5

~~M134142~~

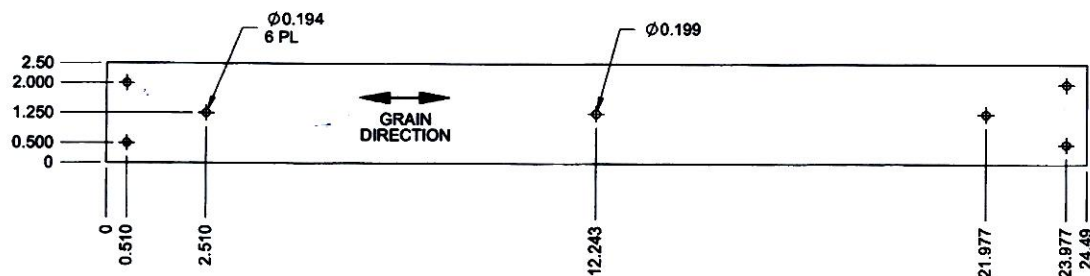
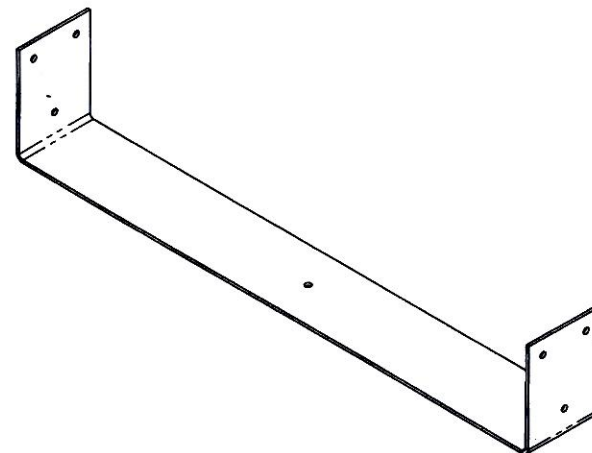
40

M135147

0.9



B67-43001-313 PLATE
(MAKE FROM B67-43001-313F)



B67-43001-313F FLAT PATTERN

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 152114 MJS
16-10-20

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.090 THICK
PER AMS-QQ-A-250/11 OR AMS 4025/4027 OR ASTM B209
REF. DART SPEC. M6061T6S.090
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.54 lbs

RELEASE
2016-02-09
ECN 16-522

D	REVISE FLAT PATTERN BASED ON K FACTOR OF 0.5 REASON: PAR 15-443	DB	15.11.25
C	REDRAWN PREMIER AVIATION DRAWING IAW DART QSI 018 AND QSI 043. FOR PREVIOUS REVISIONS, REFER TO PAGES 40 AND 43 PREMIER AVIATION DRAWING No. B67-43001. REASON: SEE PAR009-011.	MB	10.04.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED	DB	DRAWING NO.	REV. D
MFG. APPR.	DB	B67-43001-313	SHEET 1 OF 1
APPROVED	DB	TITLE	SCALE
DE APPR.	N/A	PLATE	NTS
DATE	15.11.25	COPYRIGHT © 1996 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	